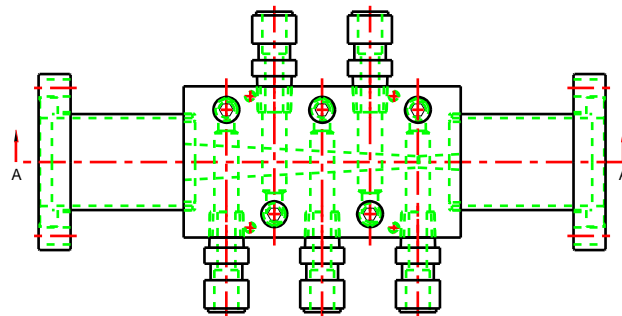
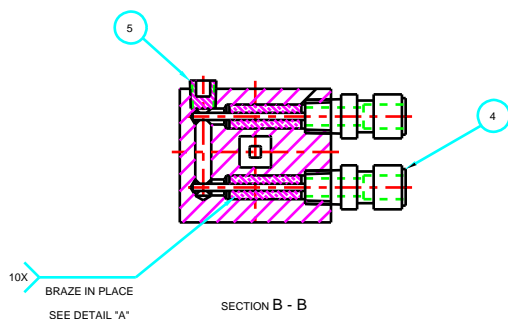


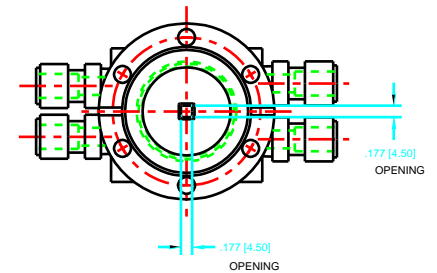
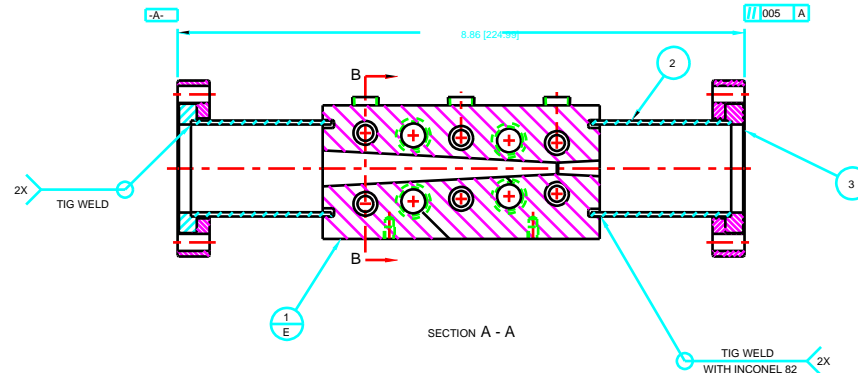
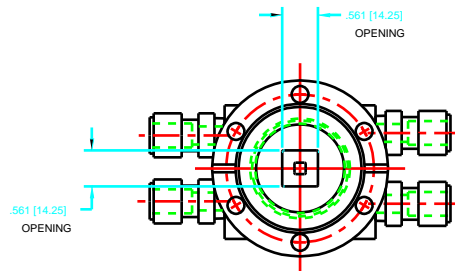
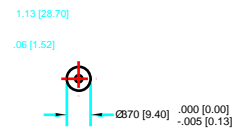
(P)	PLOT SCALE: 1=1	DWG. SCALE: 1	A2456100
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#4 - 40 X 1 3/4" LG. TIE ROD
MAT'L - 18-8 STAINLESS ST'L

MAT'L - COMMERCIAL COPPER FABRIC
8 X 8 X .0126 76% POROUS

SEE DETAIL "A"



- NOTES:
- THIS IS A ULTRA - HIGH WELDMENT ASSEMBLY (UHV)
 - WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
 - CIMCOOL 5 STAR 49
 - TRIM SOL
 - WELDMENT ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2X 10⁻¹⁰ STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:

ALCATEL ASM-110TCL
VARIAN NCR 925 OR 936
VEECO MS-9, MS-90 OR MS-18
Du PONT CEC 24-120B

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION IN THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

- WATER PRESSURE TEST AT 500 P.S.I. AFTER ASSEMBLY

- DIMENSIONS IN [] ARE MILLIMETERS AND ARE FOR REF. ONLY

REF. SOURCE

- MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA 94545-1651
TEL: 1-800-443-8817
FAX: 1-510-887-0626
- SWAGelok
DEARBORN VALVE & FITTING CO.
1540 N. OLD RAND RD.
WAUCONDA, IL. 60084-0847
TEL: 1-847-526-6900
FAX: 1-847-526-1221
- Mc MASTER-CARR SUPPLY CO.
P.O. BOX 4355
CHICAGO, IL. 60680-4355
TEL: 1-847-833-0300



5	#4638K511	1/8 N.P.T HEX SOCKET PLUG	SST	5
4	#SS-600-1-4	3/8 TUBE TO 1/4 PIPE MALE CONNECTOR	SST	10
3	#100014	2 3/4 O.D. ROTATABLE VACUUM FLANGE	SST	2
2		1 1/2 O.D. X .065 WALL X 2.21 LG. TUBING	SST	2
1	I5-910001-01	L5-91 MAIN BODY	HEAVY METAL HD 18.5	1
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X .XX - .XX (+.02) - .XX X.XX - .XX (+.02) - .XX X.XX - .XX (+.02) - .XX		LOG NUMBER I5910000-01	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY	
DRAWN BY MUSCIA	DATE 2/16/96	CHIEF DESIGN ENGINEER D. SHU	DATE 5/7/96	TITLE ADVANCED PHOTON SOURCE
DESIGNED BY D. SHU	DATE 5/7/96	PROJECT MGR. T.M. KUZAY	DATE 5/7/96	L5-91 APS UNDULATOR WHITE BEAM H & V GRAZING - INCIDENT MOVEABLE MASK WELDMENT ASSEMBLY
DESIGNER SHU/MUSCIA	DATE 2/16/96	APPROVED/RELEASED		
RESPONSIBLE ENGINEER D. SHU	DATE 5/7/96			
MATERIAL SEE PARTS LIST		SCALE 1:1	SHEET 1 of 1	DWG NUMBER I5-910000-01
DO NOT SCALE DRAWING				

1	DRAWING BROUGHT UP TO DATE	M.J.M.	J.C.	2/16/96
BY	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				